

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012512**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6 AW

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6AW Designation are as follows.

SEG27H-023, 032, 035, 036, 044, 045, 096, 099, 100

SEG027J-108, 109, 045, 046, 099, 100, 069, 019, 105

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7WEST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging on the edge

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

panel (cross beam side) splice weld between OBG segments 7BW and 7CW.

OBG SEGMENT 7EAST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging for the removing of temporary attachment (Dog plate) at the bottom panel splice weld between OBG segments 7BE and 7CE.

OBG SEGMENT 7BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058087 performing Shielded Metal Arc Welding process for weld CA036-004 located on PCMK the weld between deck panel and edge panel (bike path side). ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-2G (2F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1224.

OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066361 performing Shielded Metal Arc Welding process for weld SEG035A-021 located on PCMK the weld between side panel and bottom panel (cross beam side). ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing Shielded Metal Arc Welding process for weld SEG035A-031 located on PCMK the weld between side panel and bottom panel (counter weight side). ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067589 performing Shielded Metal Arc Welding process for weld DP640-001-12 located on PCMK the weld between deck panel "I" rib and deck panel. ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing Shielded Metal Arc Welding process for weld DP648-001-12 located on PCMK the weld between deck panel "I" rib and deck panel. ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing sand blasting in OBG segment 6 East.

OBG SEGMENT 7AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing Shielded Metal Arc Welding process for weld CA031-006 located on PCMK the weld between deck panel and e panel (cross beam side). ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

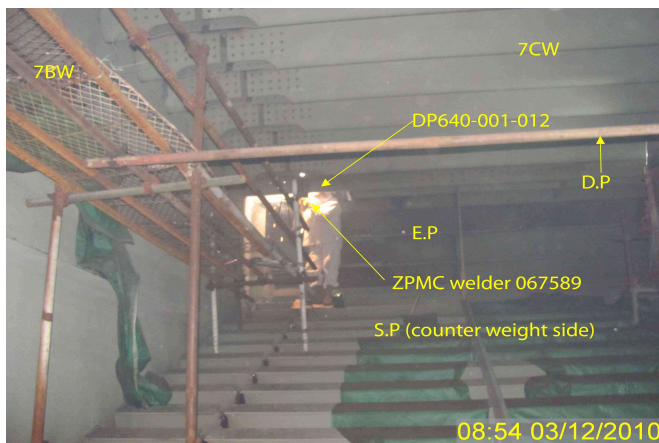
OBG SEGMENT 6WEST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing sand blasting in OBG segment 6west.

OBG SEGMENT 7BE

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection on the weld between deck panel and edge panel (cross beam side).

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
